SECTION 23 05 16

EXPANSION FITTINGS AND LOOPS FOR HVAC PIPING

PART 1 - GENERAL

1.1 RELATED DOCUMENTS

A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 SUMMARY

A. Section Includes:

1. Metal-bellows expansion joints.
2. Expansion compensators.
3. Flexible-hose expansion joints.
4. Packed slip expansion joints.
5. Flexible ball joints.
6. Pipe bends and loops.
7. Alignment guides and anchors.

1.3 DEFINITIONS

A. BR: Butyl rubber.

B. Buna-N: Nitrile rubber.

C. CR: Chlorosulfonated polyethylene synthetic rubber.

D. CSM: Chlorosulfonyl-polyethylene rubber.

E. EPDM: Ethylene-propylene-diene terpolymer rubber.

F. NR: Natural rubber.

G. PTFE: Polytetrafluoroethylene plastic.

1.4 PERFORMANCE REQUIREMENTS

A. Compatibility: Products shall be suitable for piping system fluids, materials, working pressures, and temperatures.

B. Capability: Products shall absorb 200 percent of maximum axial movement between anchors.

1.5 SUBMITTALS

A. Product Data: For each type of product indicated.

B. Delegated-Design Submittal: For each anchor and alignment guide indicated to comply with performance requirements and design criteria, including analysis data signed and sealed by the qualified professional engineer responsible for their preparation.

1. Design Calculations: Calculate requirements for thermal expansion of piping systems and for selecting and designing expansion joints, loops, and bends.
2. Anchor Details: Detail fabrication of each anchor indicated. Show dimensions and methods of assembly and attachment to building structure.
3. Alignment Guide Details: Detail field assembly and attachment to building structure.
4. Schedule: Indicate type, manufacturer's number, size, material, pressure rating, end connections, and location for each expansion joint
5. Coordination:

a. Coordinate the location of all anchors, guides and expansion devices with the structural engineer.
b. Submit details for attachment to the building structure to the structural engineer including all loads and supplemental steel.
c. Coordinate the location of items in this section with access requirements for equipment, valves, dampers, as required for work in other sections, and as indicated on the drawings.

C. Welding certificates.

D. Product Certificates: For each type of pipe expansion joint, signed by product manufacturer.

E. Maintenance Data: For pipe expansion joints to include in maintenance manuals.

F. Grooved joint couplings and fittings shall be shown on drawings and product submittals, and be specifically identified with the applicable Victaulic style or series number.

1.6 QUALITY ASSURANCE

A. Welding Qualifications: Qualify procedures and personnel according to the following:

1. Steel Shapes and Plates: AWS D1.1, "Structural Welding Code - Steel."
2. Welding to Piping: ASME Boiler and Pressure Vessel Code: Section IX.

B. Engineering Responsibility: Design and preparation of Shop Drawings and calculations for expansion fittings and loops by a qualified professional engineer

1. Professional Engineer Qualifications: A professional engineer who is legally qualified to practice in jurisdiction where Project is located and who is experienced in providing engineering services of the kind indicated. Engineering services are defined as those performed for installations of expansion fittings and loops that are similar to those indicated for this Project in material, design, and extent.

C. To assure uniformity and compatibility of piping components in grooved piping systems, all grooved products utilized shall be supplied by a single manufacturer. Grooving tools shall be supplied by the same manufacturer as the grooved components.

PART 2 - PRODUCTS

2.1 EXPANSION JOINTS

A. Metal-Bellows Expansion Joints: ASTM F 1120, circular-corrugated-bellows type with external tie rods.

1. Manufacturers: Subject to compliance with requirements, provide products by one of the following:

a. Adsco Manufacturing, LLC.
b. Badger Industries.
c. Hyspan Precision Products, Inc.
d. Metraflex, Inc.

2. Metal-Bellows Expansion Joints for Copper Piping: Single- or multiple-ply phosphor-bronze bellows, copper pipe end connections, and brass shrouds.
3. Metal-Bellows Expansion Joints for Stainless-Steel Waterway: Single-ply stainless-steel bellows, stainless-steel-pipe end connections, and steel shroud.
4. Metal-Bellows Expansion Joints for Steel Piping: Single- or multiple-ply stainless-steel bellows, steel pipe end connections, and carbon-steel shroud.
5. Minimum Pressure Rating: 150 psig unless otherwise indicated.
6. Configuration: Single- or double bellows type with base, unless otherwise indicated.
7. End Connections: Flanged welded or Brazed.

B. Expansion Compensators: Double-ply corrugated steel, stainless-steel, or copper-alloy bellows in a housing with internal guides, antitorque device, and removable end clip for positioning.

1. Manufacturers: Subject to compliance with requirements, provide products by one of the following:

a. Adsco Manufacturing, LLC.

b. Hyspan Precision Products, Inc.
c. Metraflex, Inc.

2. Minimum Pressure Rating: 150 psig unless otherwise indicated.
3. Configuration for Copper Piping: Two-ply phosphor-bronze or stainless-steel bellows and bronze or stainless-steel shroud.
4. Configuration for Steel Piping: Two-ply stainless-steel bellows and carbon-steel shroud.
5. End Connections for Copper Tubing NPS 2 and Smaller: Solder joint or threaded.
6. End Connections for Copper Tubing NPS 2-1/2 to NPS 4: Solder joint .
7. End Connections for Steel Pipe NPS 2 and Smaller: Threaded.
8. End Connections for Steel Pipe NPS 2-1/2 to NPS 4: Flanged, threaded or Welded.

C. Flexible-Hose Expansion Joints: Manufactured assembly with two flexible-metal-hose legs joined by long-radius, 180-degree return bend or center section of flexible hose; with inlet and outlet elbow fittings, corrugated-metal inner hoses, and braided outer sheaths.

1. Manufacturers: Subject to compliance with requirements, provide products by one of the following:

a. Flexicraft Industries.
b. Metraflex, Inc.

2. Flexible-Hose Expansion Joints for Copper Piping: Copper-alloy fittings with solder- joint end connections.

a. NPS 2 and Smaller: Bronze hoses and single-braid bronze sheaths with 450 psig at 70 deg F and 340 psig at 450 deg F ratings.
b. NPS 2-1/2 to NPS 4: Stainless-steel hoses and single-braid, stainless-steel sheaths with 300 psig at 70 deg F and 225 psig at 450 deg F ratings.

3. Flexible-Hose Expansion Joints for Copper Piping: Copper-alloy fittings with solder- joint end connections.

a. NPS 2 and Smaller: Bronze hoses and double-braid bronze sheaths with 700 psig at 70 deg F and 500 psig at 450 deg F ratings.
b. NPS 2-1/2 to NPS 4: Stainless-steel hoses and double-braid, stainless-steel sheaths with 420 psig at 70 deg F and 315 psig at 450 deg F ratings.

4. Flexible-Hose Expansion Joints for Steel Piping: Carbon-steel fittings with threaded end connections for NPS 2 and smaller and flanged or weld end connections for NPS 2-1/2 and larger.

a. NPS 2 and Smaller: Stainless-steel hoses and single-braid, stainless-steel sheaths with 450 psig at 70 deg F and 325 psig at 600 deg F ratings.

b. NPS 2-1/2 to NPS 6: Stainless-steel hoses and single-braid, stainless-steel sheaths with 200 psig at 70 deg F and 145 psig at 600 deg F ratings.
c. NPS 8 to NPS 12: Stainless-steel hoses and single-braid, stainless-steel sheaths with 125 psig at 70 deg F and 90 psig at 600 deg F ratings.

5. Flexible-Hose Expansion Joints for Steel Piping: Carbon-steel fittings with threaded end connections for NPS 2 and smaller and flanged or weld end connections for NPS 2-1/2 and larger.

a. NPS 2 and Smaller: Stainless-steel hoses and double-braid, stainless-steel sheaths with 700 psig at 70 deg F and 515 psig at 600 deg F ratings.
b. NPS 2-1/2 to NPS : Stainless-steel hoses and double-braid, stainless-steel sheaths with 275 psig at 70 deg F and 200 psig at 600 deg F ratings.
c. NPS 8 and Larger: Stainless-steel hoses and double-braid, stainless-steel sheaths with 165 psig at 70 deg F and 120 psig at 600 deg F ratings.

D. Packed Slip Expansion Joints: ASTM F 1007, carbon-steel, packing type designed for repacking under pressure and pressure rated for 250 psig at 400 deg F minimum. Include asbestos-free PTFE packing, compound limit stops, and drip connection if used for steam piping.

1. Manufacturers: Subject to compliance with requirements, provide products by one of the following:

a. Adsco Manufacturing, LLC. Type RJ
b. Advanced Thermal Systems, Inc. Thermal Pak-Type TP2
c. Hyspan Precision Products, Inc.

2. Configuration: Single- and double joint class with base, unless otherwise indicated.
3. End Connections: Flanged or weld ends to match piping system.

E. Packed type: Provide single or double slip, with anchor base except as noted. Provide internal and external guides integral with stuffing box; wrought steel with chromium plating applied directly to polished steel surface. Provide butt weld ends, except as noted.

1. Provide limit stops, capable of holding against full internal thrust.
2. Packing: Provide self-lubricating asbestos-free polytetrafluoroethylene or asbestos-free reinforced teflon type, which can be injected under full line pressure, contained by minimum of 3 teflon non-asbestos rings at each side.
3. Provide joints body of weldable quality carbon steel, ASTM 53 grade B seamless pipe with drip connection if used for steam service.
4. Slip requirements: Provide ASTM A 53 grade B seamless pipe up to and including 12 inch: Schedule 80 and 16 inch through 24 inch: Schedule 60.

a. Provide wall thickness after machining not reduced more than 1/8 inch.

b. Provide double layer of chrome plating with minimum thickness 0.001 inch each after buffing. First layer: crack-free hard chrome; second layer: standard hard chrome.

5. Provide welded steel packing cylinder with internal acme thread and male threaded plunger with cylinder welded directly to stuffing box. Minimum number of packing cylinders as follows:

Expansion Joint Size	Number of Packing Cylinders
1-1/2 inch thru 4 inch	1
5 inch and 6 inch	3
8 inch and 10 inch	4
12 inch and 14 inch	5
16 inch and 18 inch	6
20 inch and 24 inch	8

6. Pressure ratings:

   a. All piping: 150 lb.

7. Provide all welding in accordance with Section IX of ASME Boiler and Pressure Vessel Code.

F. Flexible Ball Joints: Carbon-steel assembly with asbestos-free composition packing, designed for 360-degree rotation and angular deflection, and 250 psig at 400 deg F minimum pressure rating; complying with ASME Boiler and Pressure Vessel Code: Section II, "Materials," and with ASME B31.9, "Building Services Piping," for materials and design of pressure-containing parts and bolting.

1. Angular Deflection for NPS 6 and Smaller: 30-degree minimum.
2. Angular Deflection for NPS 8 and Larger: 15-degree minimum.
3. End Connections for NPS 2 and Smaller: Threaded.
4. End Connections for NPS 2-1/2 and Larger: Flanged.
5. Manufacturers: Subject to compliance with requirements, provide products by one of the following:

   a. Advanced Thermal Systems, Inc.
   b. Hyspan Precision Products, Inc.

G. Grooved End Expansion Joints for Steel Piping: Use in water piping systems 2-1/2" and larger that are installed within enclosures where a pipe bend or loop cannot be applied. Grooved joints not to be used on hot water systems.

1. Manufacturers: Subject to compliance with requirements provide products by one of the following:

   a. Victaulic Company

2. 2" Through 6": Packless, gasketed, slip-type expansion joint with grooved end telescoping body for installation with Victaulic Style 07 rigid couplings. Provides axial end movement to 3", designed for water services up to 230°F and working pressure to 350 psi. Victaulic Style 150 Mover®.
3. 2" Through 24: Combination of short nipples and Victaulic Style 75 or 77 flexible couplings joined in tandem for increased expansion. Joint movement and expansion capabilities dependent on number of couplings/nipples used in the joint. Pressure rating dependent on size and style of flexible couplings used. Victaulic Style 155.

2.2 ALIGNMENT GUIDES

A. Description: Steel, factory fabricated, with bolted two-section outer cylinder and base for alignment of piping and two-section guiding spider for bolting to pipe.

1. Manufacturers: Subject to compliance with requirements, provide products by one of the following:

   a. Adsco Manufacturing, LLC.
   b. Advanced Thermal Systems, Inc.
   c. B-Line systems, Inc.
   d. Grinnell Corp.

2.3 MATERIALS FOR ANCHORS

A. Steel Shapes and Plates: ASTM A 36/A 36M.

B. Bolts and Nuts: ASME B18.10 or ASTM A 183, steel, hex head.

C. Washers: ASTM F 844, steel, plain, flat washers.

D. Mechanical Fasteners: Insert-wedge-type stud with expansion plug anchor for use in hardened portland cement concrete, and tension and shear capacities appropriate for application.

1. Stud: Threaded, zinc-coated carbon steel.
2. Expansion Plug: Zinc-coated steel.
3. Washer and Nut: Zinc-coated steel.

E. Chemical Fasteners: Insert-type-stud bonding system anchor for use with hardened portland cement concrete, and tension and shear capacities appropriate for application.

1. Bonding Material: ASTM C 881, Type IV, Grade 3, 2-component epoxy resin suitable for surface temperature of hardened concrete where fastener is to be installed.
2. Stud: ASTM A 307, zinc-coated carbon steel with continuous thread on stud, unless otherwise indicated.
3. Washer and Nut: Zinc-coated steel.

F. Concrete: Portland cement mix, 3000 psi minimum. Comply with requirements in Division 03 Section "Cast-in-Place Concrete" for formwork, reinforcement, and concrete.

G. Grout: ASTM C 1107, factory-mixed and -packaged, dry, hydraulic-cement, nonshrink, nonmetallic grout; suitable for interior and exterior applications.

1. Properties: Nonstaining, noncorrosive, and nongaseous.
2. Design Mix: 5000-psi, 28-day compressive strength.

PART 3 - EXECUTION

3.1 EXPANSION-JOINT INSTALLATION

A. Install manufactured, nonmetallic expansion joints according to FSA's "Technical Handbook: Non-Metallic Expansion Joints and Flexible Pipe Connectors."

B. Install expansion joints of sizes matching size of piping in which they are installed.

C. Install alignment guides to allow expansion and to avoid end-loading and torsional stress.

D. Grooved joint piping systems shall be installed in accordance with the manufacturer's guidelines and recommendations. All grooved couplings, fittings, valves and specialties shall be supplied by a single manufacturer. Grooving tools shall be supplied by the same manufacturer as the grooved components. The gasket style and elastomeric material (grade) shall be verified as suitable for the intended service as specified. Gaskets shall be developed and supplied by the manufacturer. Grooved end shall be clean and free from indentations, projections and roll marks in the area from pipe end to groove. A factory trained field representative shall provide on-site training to contractor's field personnel in the installation of grooved piping products. Factory trained representative shall periodically review the product installation. Contractor shall remove and replace any improperly installed products.

3.2 PIPE BEND AND LOOP INSTALLATION

A. Install pipe bends and loops cold-sprung in tension or compression as required to partly absorb tension or compression produced during anticipated change in temperature.

B. Expansion: Install piping to permit free expansion and contraction without damaging piping or construction.

1. Provide offsets, expansion loops, anchors, guides and supports to permit expansion, with stress limits of ASME Code for Pressure Piping for temperature range of 40 deg F to minimum of 20 deg F above maximum system temperature.

C. Attach pipe bends and loops to anchors.

1. Steel Anchors: Attach by welding. Comply with ASME B31.9 and ASME Boiler and Pressure Vessel Code: Section IX, "Welding and Brazing Qualifications."
2. Concrete Anchors: Attach by fasteners. Follow fastener manufacturer's written instructions.

3.3 SWING CONNECTIONS

A. Connect risers and branch connections to mains with at least five pipe fittings, including tee in main.

B. Connect risers and branch connections to terminal units with at least four pipe fittings, including tee in riser.

C. Connect mains and branch connections to terminal units with at least four pipe fittings, including tee in main.

3.4 ALIGNMENT-GUIDE INSTALLATION

A. Install guides on piping adjoining pipe expansion fittings and loops.

B. Attach guides to pipe and secure to building structure.

3.5 ANCHOR INSTALLATION

A. Install anchors at locations to prevent stresses from exceeding those permitted by ASME B31.9 and to prevent transfer of loading and stresses to connected equipment.

B. Fabricate and install steel anchors by welding steel shapes, plates, and bars to piping and to structure. Comply with ASME B31.9 and AWS D1.1.

C. Construct concrete anchors of poured-in-place concrete of dimensions indicated and include embedded fasteners.

D. Install pipe anchors according to expansion-joint manufacturer's written instructions if expansion joints or compensators are indicated.

E. Use grout to form flat bearing surfaces for expansion fittings, guides, and anchors installed on or in concrete.

3.6 PAINTING

A. Touching Up: Clean field welds and abraded areas of shop paint. Paint exposed areas immediately after erecting hangers and supports. Use same materials as used for shop painting. Comply with SSPC-PA 1 requirements for touching up field-painted surfaces.

1. Apply paint by brush or spray to provide a minimum dry film thickness of 2.0 mils.

B. Galvanized Surfaces: Clean welds, bolted connections, and abraded areas and apply galvanizing-repair paint to comply with ASTM A 780.

END OF SECTION